

Date: Monday, 12/05/2008 9:58:07 AM  
User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206 EXTRUSION BENDING  
Job Number : 39178  
Estimate Number : 10311  
P.O. Number : Part Number : D2620  
This Issue : 12/05/2008 S.O. No. : Drawing Number : D2620 REV B  
Prsht Rev. : NC Project Number : N/A  
First Issue : / / Type : SKIDTUBES Drawing Revision : B  
Previous Run : 39154 Material :  
Written By : Due Date : 25/05/2008 Qty: 20 Um: Each  
Checked & Approved By : JUD 08-5-12  
Comment : Est. D 02.07.26 Change Dwg to rev.B; Updated Location RF

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D26001160 Extrusion Round 3" 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Extrusion Round 3" 206

Pick;

Qty Part Number Description Batch  
1 D2600-1 Extrusion Round 3"206

Batch

34715<sup>x9</sup> / 24508<sup>x11</sup>

2.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A  
and Folio Ft008

2- Cut Fwd end of tube as per Dwg D2620

AWM / 8-5-12 (20)

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/13 (20)

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: skid tube cell

RT 08-05-13 (20)

5.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/14

Job Completion



08-05-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	2						

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

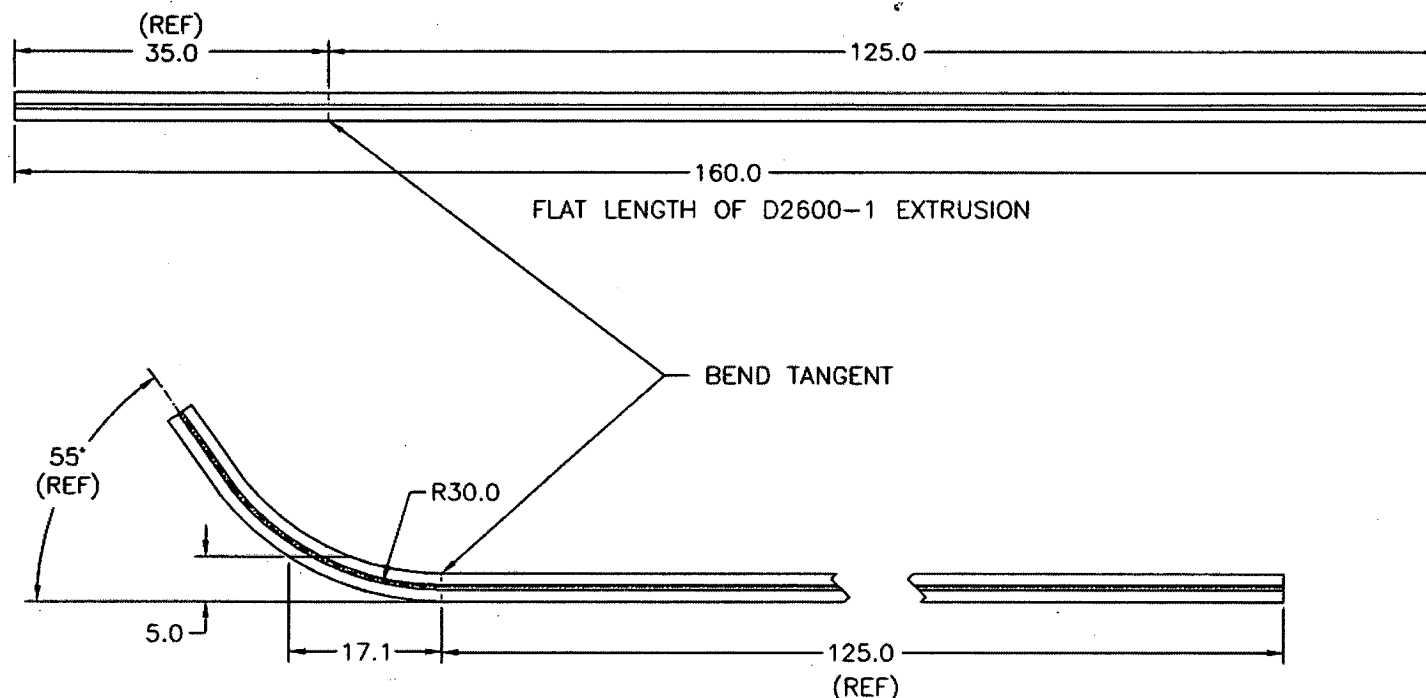
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# SPECIFICATION CONTROL DRAWING

## 206 SKIDTUBE BENDING



### DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE. NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE  $3.20 \pm 0.200$  IN THE BEND. TUBE WIDTH SHOULD BE  $3.200 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE. TUBE HEIGHT SHOULD BE  $3.15 \pm 0.200$  IN THE BEND. TUBE HEIGHT SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES



DESIGN	RF	DRAWN BY	RF	DART AEROSPACE USA, INC.
CHECKED	KE	APPROVED	KE	FAIRCHILD INTERNATIONAL AIRPORT, WA
DATE	99.09.10	DRAWING NO.	D2620	REV. B
TITLE	206 SKIDTUBE BENDING CONTROL	SHEET 1 OF 1	SCALE	1:20
A	97.11.07	NEW ISSUE		
B	97.09.10	UPDATE FOR IN-HOUSE BENDING		

RELEASED  
49.04.15 DS